Work Order ID 69927

Tuesday, May 24, 2011 2:22:58 PM

Item ID: D2939-1 **Accept** **Setup Start**

Revision ID:

Item Name: Saddle LH In, 206 **Stop**

Start Date: 5/24/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** P **Date:** 11-05-24 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2939	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00				6	ϕ		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number.☐1-Inspect part number and batch number are programmed correctly.☐2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐3-Machine Step No 2 of Folio and visually inspect as per JL 11-07-19								
110	CONVENTIONAL MILLING MACHINE	0.00				6	ϕ		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet JL 11-07-19								
120	QC1- Inspect dimensions to dimension sheet	0.00				6	ϕ		
QC	**Memo**	0.00	JL 11-07-19						
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC			B.A 11/07/19			6	ϕ		
Quality Control	**Memo**	0.00							
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish						6	BK 11-7-20		
Hand Finishing	**Memo**	0.00							
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	M117745					6	BK 11-7-20		
Powder Coating	**Memo** START TIME: 1:15. ☐OVEN TEMPERATURE: 388 ☐FINISH TIME: 145	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 69927

Tuesday, May 24, 2011 2:22:58 PM

Item ID: D2939-1 **Accept** **Setup Start**

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Item Name: Saddle LH In, 206

Start Date: 5/24/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 5/31/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				6	ϕ		MD 11/07/20
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location 429	0.00							4/2/20 (6)
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							11/7/21
QC	Memo	0.00							
Quality Control									

MF
11-07-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Tuesday, May 24, 2011 2:23:06 PM

Work Order ID: 69927

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206

Start Date: 5/24/2011 **Required Date:** 5/31/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	51.0000	1	6 JL 11-07-18			

Location	Loc Qty	Loc Code
MAT040	51	
64777	20	
66965	10	
68170	21	

70976

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	69927
Description: 206 Saddle, Inboard, Left side	**Part Number:**	**D2939-1**
Inspection Dwg: D2939 Rev. C		**Page 1 of 1**

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	5 ~~**By**~~	6 ~~**Date**~~
A	0.100	0.140		.120	.118	.120	.118	.118	.119
B	0.100	0.140		.119	.120	.120	.119	.119	.119
C	0.100	0.140		.115	.114	.115	.115	.115	.115
D	0.210	0.230		.220	.221	.220	.221	.220	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257	.257
L	0.312	0.317		.313	.313	.313	.313	.313	.313
M	0.235	0.240		.238	.238	.238	.238	.238	.238
N	0.100	0.140		.120	.121	.120	.120	.121	.120
O	0.540	0.560		.550	.550	.549	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.251	.250	.250	.249	.249	.249
T	0.100	0.180		.140	.140	.140	.140	.140	.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316	.316
X	1.250	1.270		1.259	1.262	1.261	1.262	1.262	1.261
Y	1.565	1.585	DT8695 A/B	1.574	1.577	1.576	1.577	1.577	1.576
Z	0.178	0.198		.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	11-07-19

Audited by	B.A
Date:	11/07/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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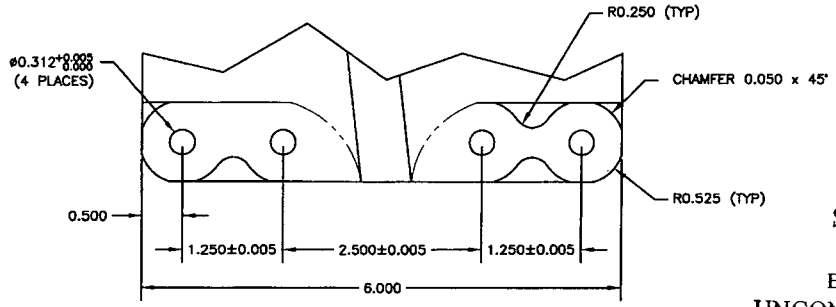
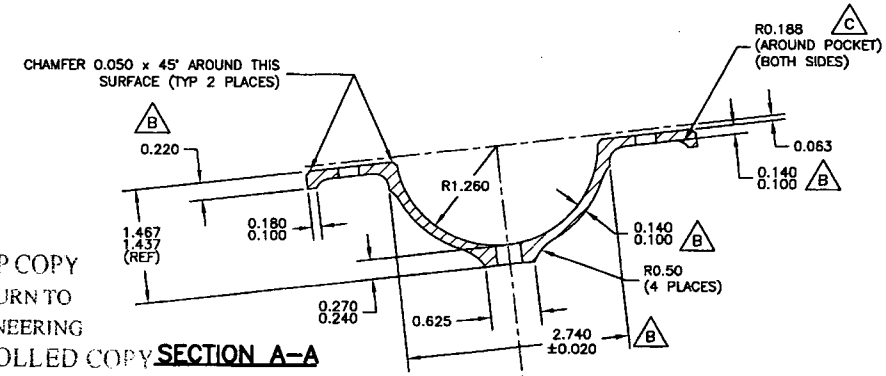


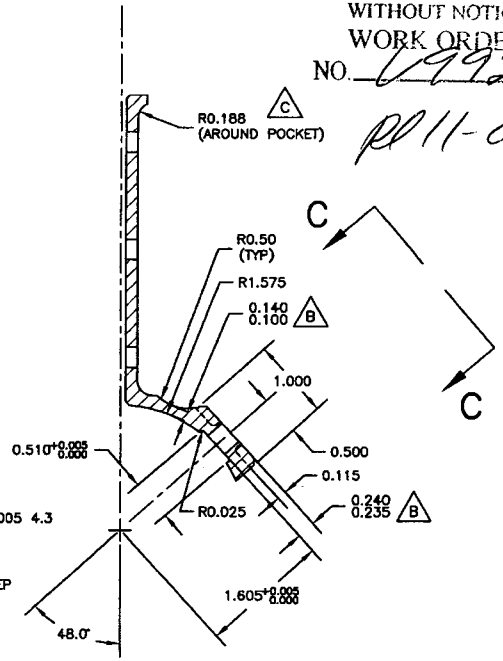
VIEW C–C



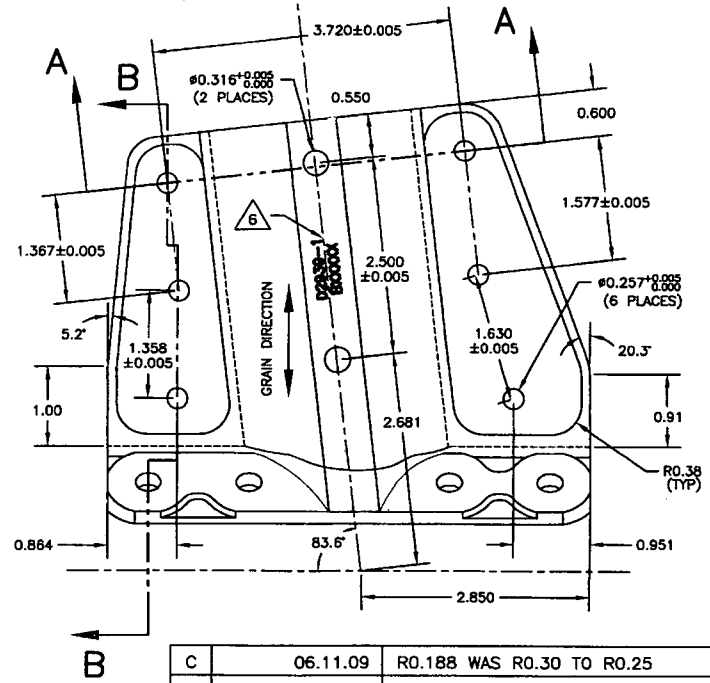
SECTION A–A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69927
RW 11-05-24

D2939–1 LH SADDLE (SHOWN)
D2939–2 RH SADDLE (OPPOSITE)



SECTION B–B



NOTES:
1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12)
(MAKE FROM D6101–001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

07.02.12

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

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DESIGN	DRAWN BY CB	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED PH	APPROVED	DRAWING NO. D2939	REV. C SHEET 1 OF 1
DATE 06.11.09		TITLE SADDLE INSIDE	SCALE 2:3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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